

Date: Tuesday, 1/15/2008 9:49:46 AM  
 User: Kim Johnston

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	TUBE		
Job Number	36774			Part Number	D22825		
Estimate Number	11175			Drawing Number	D2282 REV E		
P.O. Number				Project Number	N/A		
This Issue	1/15/2008	S.O. No.		Drawing Revision	E		
Prsht Rev.	NC			Material			
First Issue	/ /	Type	MACHINED PARTS	Due Date	2/10/2008	Qty:	200
Previous Run	35473			Um:	Each		
Written By	<u>KJ</u> 080115						
Checked & Approved By							
Comment	Est Rev:A	Removed from 9 Digit	05-12-02 JLM				

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:	
1.0	M304R0750	Inventory	
	Comment: Qty.: 0.1891 f(s)/Unit Total : 37.8126 f(s) Material: AISI 304 Stainless Steel Ø0.750(M304R0.750) Batch M106858		<u>H.A</u> 08/01/19
2.0	HARDINGE	HARDINGE CNC LATHE SMALL	
	Comment: HARDINGE CNC LATHE SMALL		
	1-Turn as per Dwg D2282 and Folio FA189		
	2-Deburr		<u>J.F. / H.A/gml</u> 08/01/19
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE		<u>J.F. / H.A/gml</u> 08/01/19
4.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	
	Comment: CONVENTIONAL MILLING MACHINE Mill Arc as per Dwg D2282		<u>gml</u> 08/02/08
5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE		<u>gml</u> 08/02/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services	Drawing Name: TUBE	
Job Number: 36774	Part Number: D22825	
Job Number:		
Seq. #:	Machine Or Operation:	Description :
6.0	QC8	SECOND CHECK 
7.0	PACKAGING 1	PACKAGING RESOURCE #1 
8.0	QC21	FINAL INSPECTION/W/O RELEASE 

Comment: SECOND CHECK

SG 08.02.08 (201)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: PAT.DVNL

AS 08/02/11

(201)

Comment: FINAL INSPECTION/W/O RELEASE

08.02.13 (201)

Job Completion



~~3677~~  
in 2008/2/11

(201)

W

W/I/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	36774
Description: Handle Tube	Part Number:	D2282-5
Inspection Dwg: D2282 Rev: E		Page 1 of 1

## **FIRST ARTICLE INSPECTION CHECKLIST**

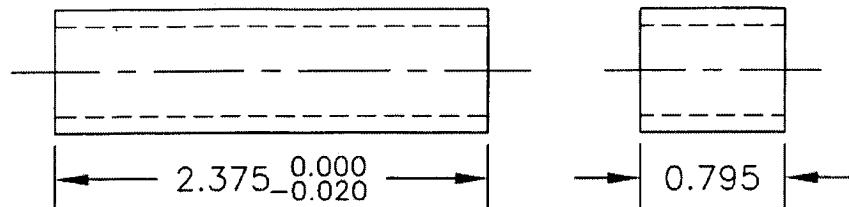
## X First Article      Prototype

Measured by:	<u>J.F</u>	Audited by:	<u>BF</u>	Prototype Approval:	N/A
Date:	08/01/19	Date:	08/01/19	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.11.11	New Issue P/O D350-615-041	KJ/RF	
B	05.04.19	Dimensions & tolerances changed	KJ/JLM	
C	06.03.15	Dimensions & tolerances revised per Dwg Rev E	KJ/JLM	
D	07.11.26	Ø0.700 dimension added	KJ/EC/DD	✓ ✓



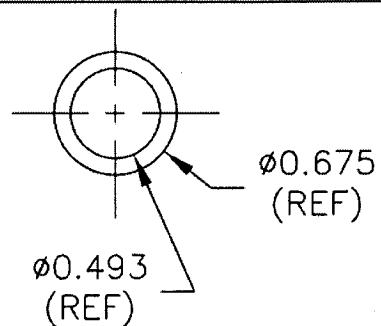
DESIGN BW	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>IP</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2282	REV. E SHEET 1 OF 2
DATE 05.06.07		TITLE HANDLE TUBES	SCALE 1:1
A	94.10.14	NEW ISSUE	
B	95.03.23	RE-DESIGN	
C	97.10.20	CORRECTED NUMBERING SCHEME	
D	05.03.16	REDESIGN D2282-5; 0.795 WAS 0.750	
E	05.06.07	D2282-5 304 SS WAS 303 SS; R0.063 x 0.063 WAS R0.080 x 0.030	



D2282-3

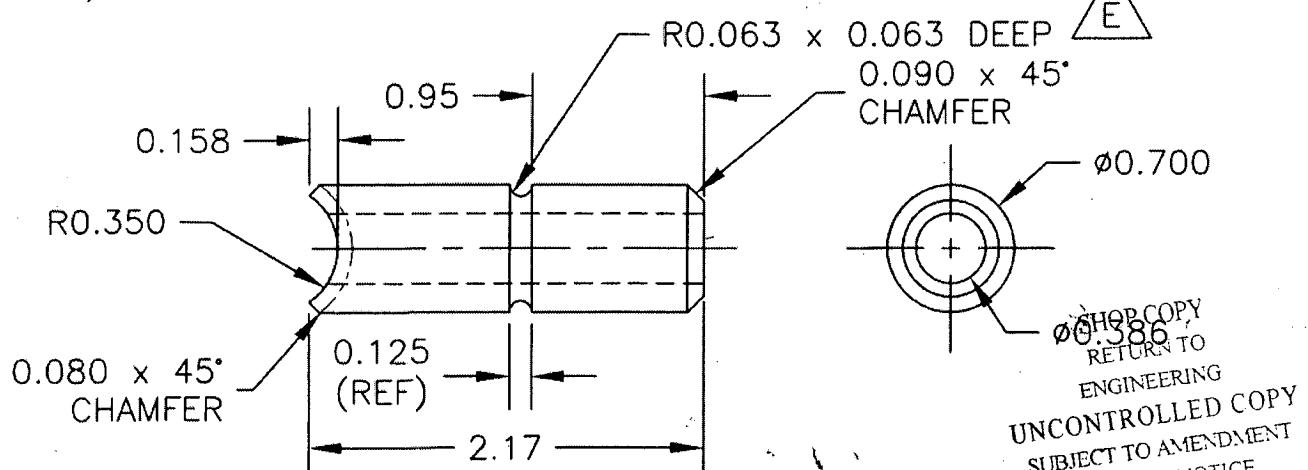


D2282-7



#### D2282-3/-7 TUBE:

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D2282-5

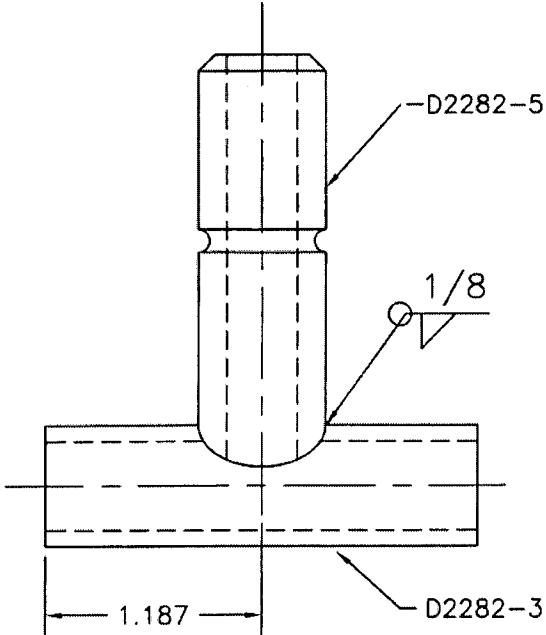
#### D2282-5 STEM:

- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

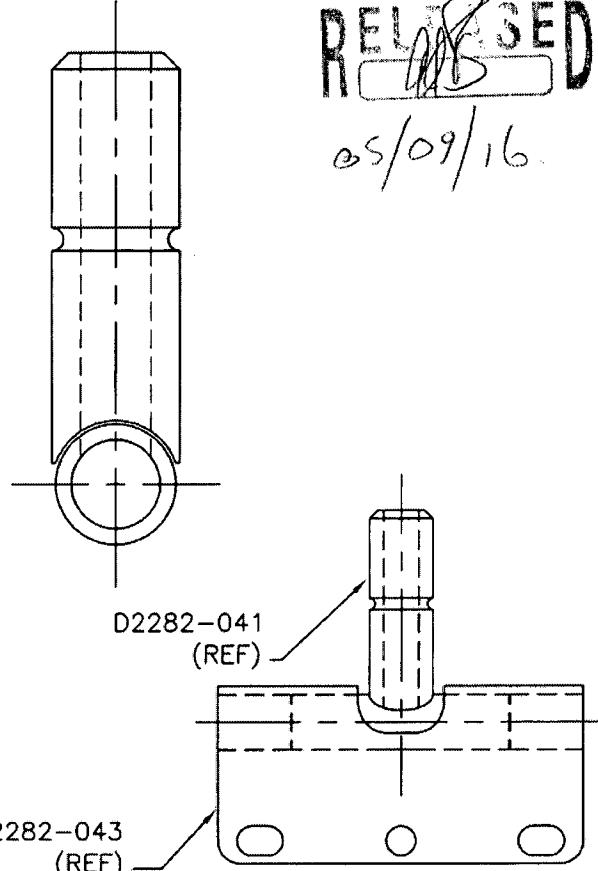


**DART**

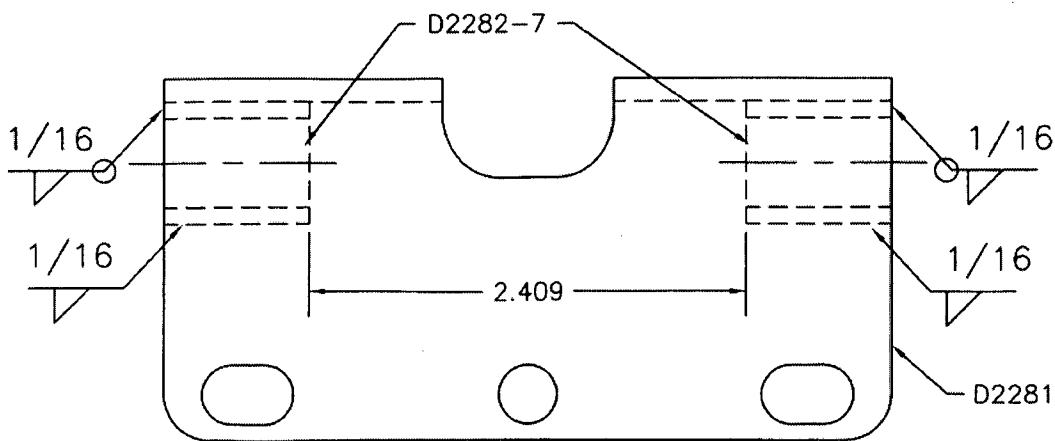
DESIGN BW	DRAWN BY <i>RF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>UP</i>	APPROVED <i>AB</i>	DRAWING NO. D2282	REV. E SHEET 2 OF 2
DATE 05.06.07		TITLE HANDLE TUBES	SCALE 1:1



D2282-041 'T' ASSEMBLY  
WELD ASSEMBLY PER DART QSI 004



GENERAL ASSEMBLY  
SCALE 1:2



D2282-043 SADDLE ASSEMBLY  
WELD ASSEMBLY PER DART QSI 004

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *36774*